

Date: Monday, 12/5/2005 9:24:21 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 25098	
Estimate Number : 10379	
P.O. Number : NA	Part Number : D3195041
This Issue : 12/5/2005 S.O. No. : N/A	Drawing Number : D3195 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/5/2005 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : See Comment below	Due Date : 12/20/2005
Checked & Approved By : See Comment below	Qty: 10 Um: Each
Comment : Est Rev:A New Issue 05-11-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X02000	6061-T6 Bar .75" x 2.0"
Comment: Qty.: 0.3150 f(s)/Unit Total : 3.1500 f(s) Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B0.750x02.000) Identify for D3195-1 Batch: M 9601 63" J.G 05/12/06 10		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: (0.75" x 2.00") x 3.60" long J.G 05/12/06 10		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1 2-Deburr J.G 05.12.09 10		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.G 05.12.09 10		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK J.G 05/12/09 10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: [Signature] Date: 8/8/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:24:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25098

Part Number: D3195041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SA01 12/11/05/10

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

ml 06/01/11 10

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/01/12 10

9.0	D31955	Pad
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D3195-5	PAD	B25114
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SB 06/01/12 10

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3195-5 into D3195-1 as per Dwg D3195Pick:

Qty	Description	Batch
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A/RContact Cement	M16194	
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Identify as D3195-041

SB 06/01/12 10

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

U 06/01/12 10

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 90

CY 06/01/12 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:24:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25098

Part Number: D3195041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

 06/01/12

Job Completion



u 06-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25098
Description: Bracket		Part Number: D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.265	+/-0.010	1.268	/			
0.242	+/-0.010	.239	/			
1.084	+/-0.010	1.079	/			
R0.200	+/-0.010	R.200	/			
R0.377	+/-0.010	R.375	/			
Ø0.277	+0.005/-0.000	Ø.278	/			
2.677	+/-0.005	2.676	/			
3.432	+/-0.010	3.426	/			
0.754	+/-0.010	.751	/			
1.387	+/-0.010	1.383	/			
0.500	+/-0.010	.499	/			
0.250	+/-0.005	.251	/			
1.754	+/-0.010	1.750	/			
Ø0.191	+0.005/-0.000	Ø.192	/			
.376	±.005	.374	/			
.377	±.005	.376	/			

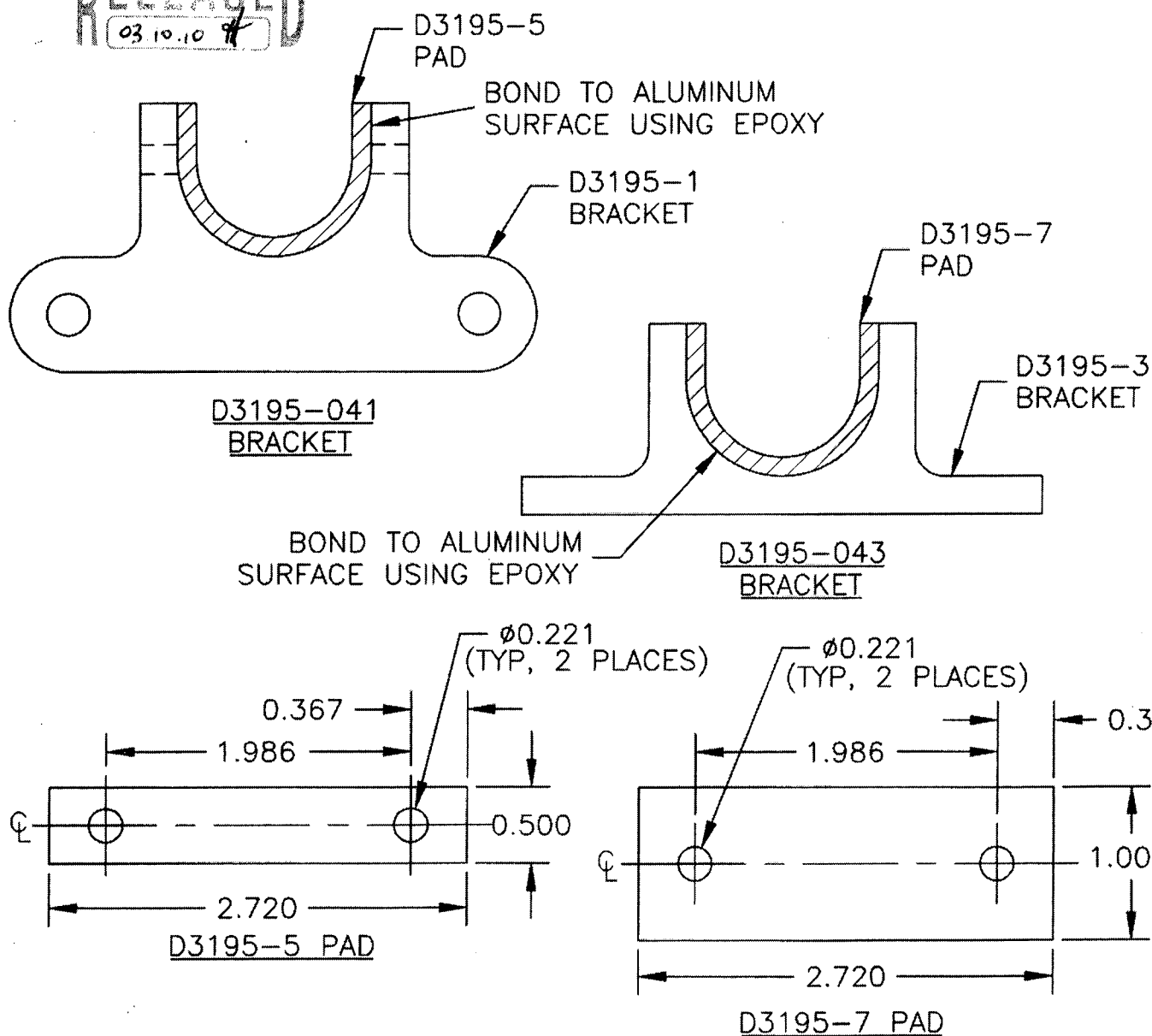
Measured by: SA	Audited by: S.G.	Prototype Approval: N/A
Date: 05.12.09	Date: 05/12/09	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-13)	KJ/RF	



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
CHECKED	#	APPROVED	#	D3195	SHEET 1 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE	1:1
A	03.06.23	NEW ISSUE			

RELEASED
03.10.10 #



D3195-5 & D3195-7 PAD

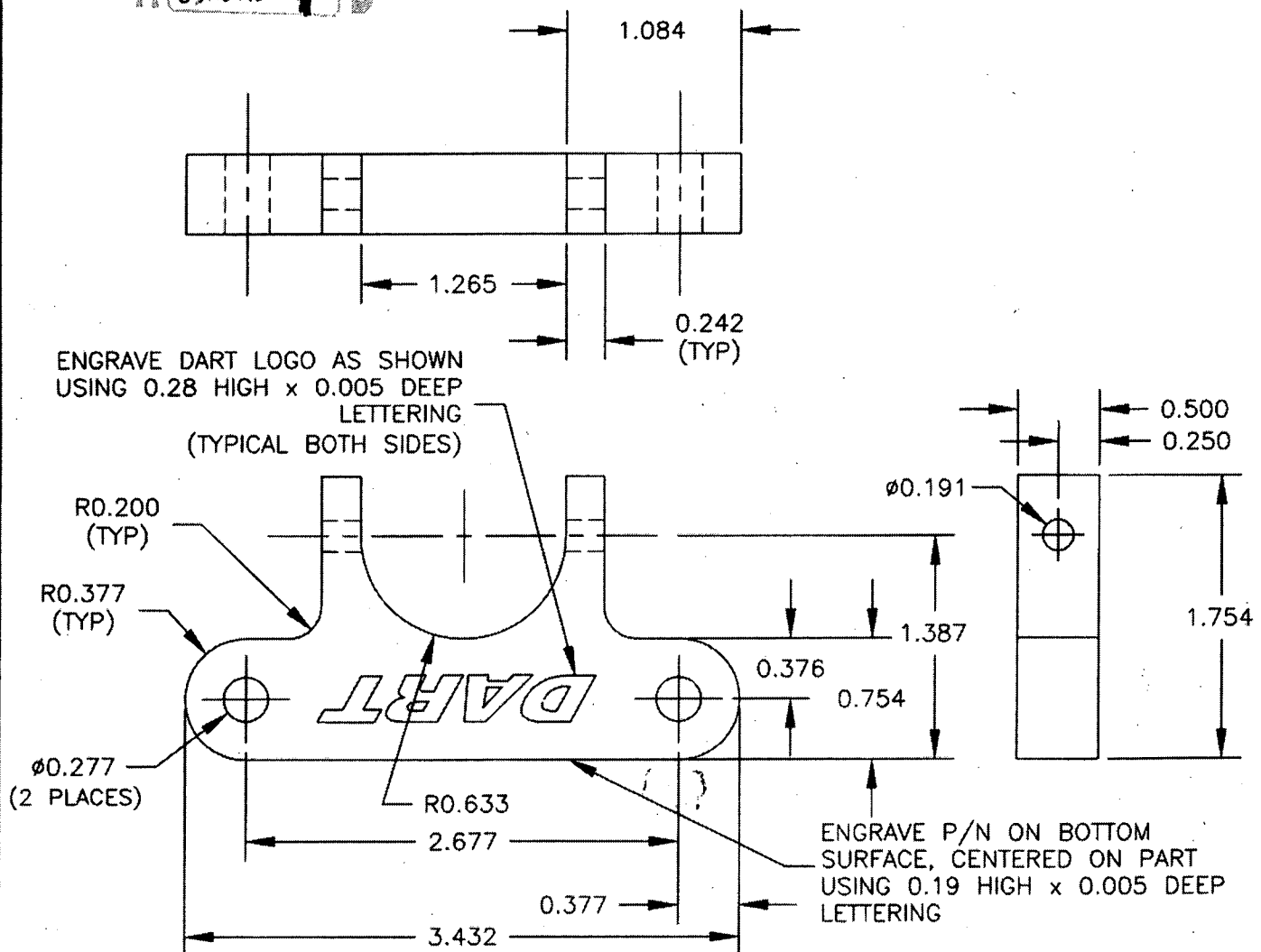
- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10**D3195-1 BRACKET**

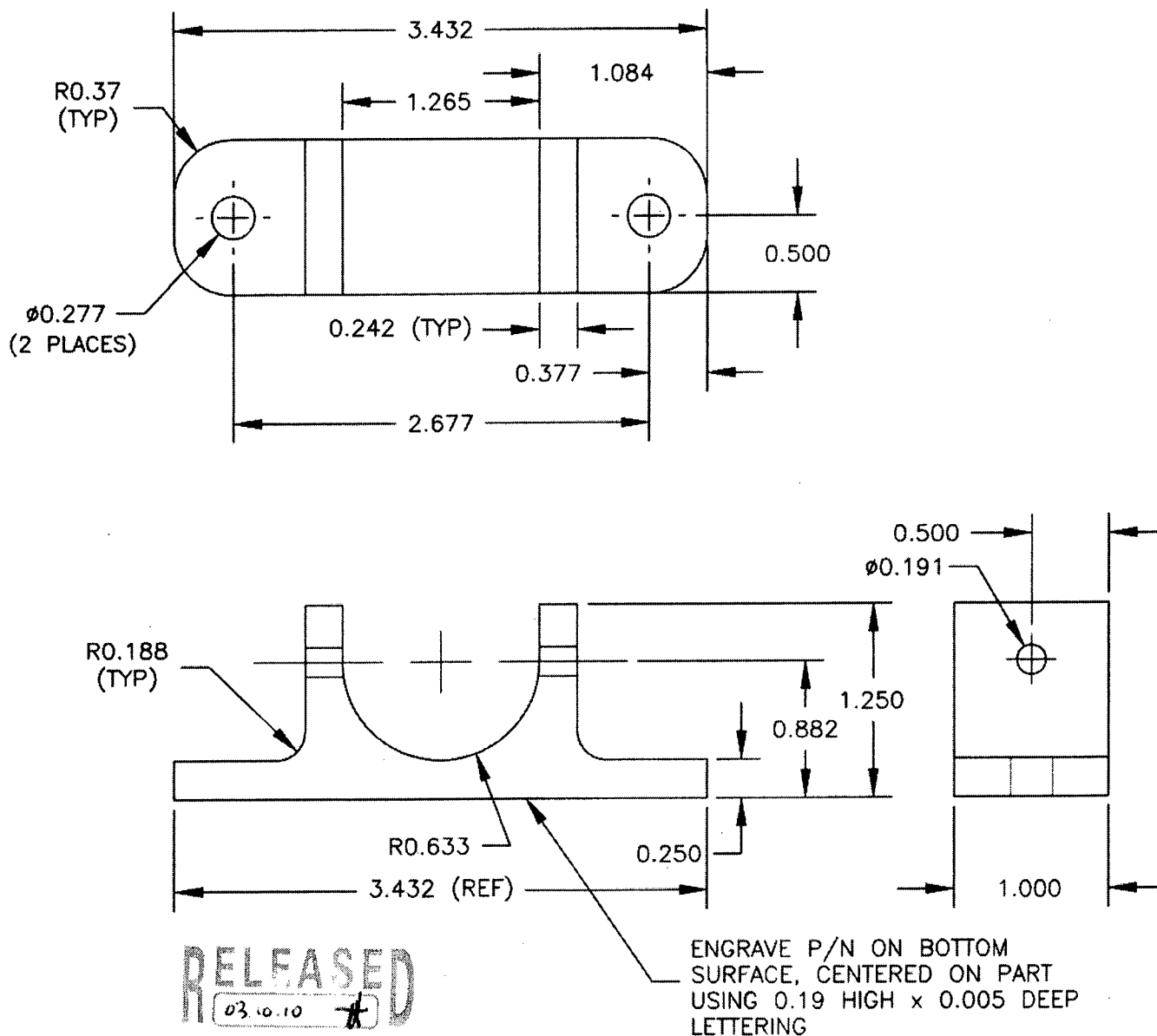
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED
03.10.10

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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